

# Work Order ID 61403



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August 24, 2010 9:01:05 AM

Item ID: D412-698-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 8/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CX Date: 10/8/24

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|              |       |
|--------------|-------|
| IIN D412-698 | Rev E |
|--------------|-------|

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

*S10609/23*

*H Col BG 10-8-25*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*10/8/24 SL 48*

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

*S10609/23*

*44*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 61403

August 24, 2010 9:01:05 AM



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Item ID: D412-698-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Cabin Door Roller, RH

Start Date: 8/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 9/07/10 Req'd Qty: 4.00

Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

| Sequence ID/<br>Work Center ID | Operation<br>Description                               | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Packaging  | 0.00                 |         |        |              |               |               |                  |                |
|                                | Packaging  |                      |         |        |              |               |               |                  |                |
|                                | Packaging  |                      |         |        |              |               |               |                  |                |
|                                | Memo   | 0.00                 |         |        |              |               |               |                  |                |
|                                | Identify and pack for shipping as per PPP D412-698-012 |                      |         |        |              |               |               |                  |                |
|                                | Location: _____  |                      |         |        |              |               |               |                  |                |
|                                |  |                      |         |        |              |               |               |                  |                |
| 140                            | QC21- Final Inspection - Work Order Release            | 0.00                 |         |        |              |               |               |                  |                |
|                                | QC   |                      |         |        |              |               |               |                  |                |
|                                | Quality Control  |                      |         |        |              |               |               |                  |                |

*Handwritten signature: C. P. / 23 (4)*

*Handwritten date and initials: 10/09/24 JH*

*Handwritten initials and date: MF 10-9-23*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61403

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH

Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: C 04.02.26 Change Qty of D3121-141 & remove D3121-145 from  
Step 1, 3 KJ/DS  
IPP Rev: D 08-01-28 change to rev D ECN 1104 DD

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3121-141<br>Bracket Assembly   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 12.0000        | 3           | 12           |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | ST235A              |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 60291               |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| D3121-144<br>Bracket Assembly   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 4.0000         | 1           | 4            |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | ST235A              |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 60292               |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| D3137-043<br>Bracket Assembly   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 5.0000         | 1           | 4            |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | ST235B              |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 59916               |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |
| D3183-044<br>Bracket Assembly   |                        | Manufactured  | No          |                     |                  | 110             | Each               | 4.0000         | 1           | 4            |               |                |        |
|                                 |                        |               |             | <u>Location</u>     |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | ST236               |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             | 60293               |                  |                 |                    |                |             |              |               |                |        |
|                                 |                        |               |             |                     |                  |                 |                    |                |             |              |               |                |        |

61483  
10/8/24 SP  
2x B61728 10/9/20 SP  
2x  
B61481 10/9/20 SP  
10/8/24 SP  
B61482 2x  
10/9/20 SP

2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

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Work Order ID: 61403

Parent Item: D412-698-012

Parent Item Name: Cabin Door Roller, RH



Start Date: 8/24/10

Required Date: 9/07/10

Start Qty: 4.00

Required Qty: 4.00

D3199-1

Manufactured No

110

Each

86.0000



10/8/04 sf



Bracket

Location

Loc Qty

Loc Code

ST236A

86

60066

53

60498

33

17  
19

(4x)

D3202-1

Manufactured No

110

Each

3.0000



B61694 10/12/10 sf



Cover

Location

Loc Qty

Loc Code

ST241A

3

50134

3

-4

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



## 6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

| Qty<br>-011 | Qty<br>-012 | Qty<br>-013 | Qty<br>-017 | Qty<br>-019 | Qty<br>-021 | Part Number  | Description                |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|----------------------------|
| X           |             |             |             |             |             | D412-698-011 | CABIN DOOR ROLLER KIT, LH  |
|             | X           |             |             |             |             | D412-698-012 | CABIN DOOR ROLLER KIT, RH  |
|             |             | X           |             |             |             | D412-698-013 | DOOR HANDLE KIT            |
|             |             |             | X           |             |             | D412-698-017 | REPLACEMENT DOOR TRACK KIT |
|             |             |             |             | X           |             | D412-698-019 | BEARING OVERHAUL KIT       |
|             |             |             |             |             | X           | D412-698-021 | REPLACEMENT SHIM KIT       |
| 3           | 3           |             |             |             |             | D3121-141    | BRACKET ASSEMBLY           |
| 1           |             |             |             |             |             | D3121-143    | BRACKET ASSEMBLY           |
|             | 1           |             |             |             |             | D3121-144    | BRACKET ASSEMBLY           |
| 1           | 1           |             |             |             |             | D3137-043    | BRACKET ASSEMBLY           |
| 1           |             |             |             |             |             | D3183-043    | BRACKET ASSEMBLY           |
|             | 1           |             |             |             |             | D3183-044    | BRACKET ASSEMBLY           |
| 9           | 9           |             | 9           |             |             | D3199-1      | BRACKET                    |
| 1           | 1           |             | 1           |             |             | D3202-1      | COVER                      |
|             |             | 4           |             |             |             | D3203-1      | HANDLE                     |
|             |             | 1           |             |             |             | D3220-041    | DOUBLER                    |
|             |             | 1           |             |             |             | D3220-042    | DOUBLER                    |
|             |             | 2           |             |             |             | D3220-3      | DOUBLER                    |
|             |             |             |             | 7           |             | D3121-21     | BOLT                       |
|             |             |             |             | 5           |             | D3121-241    | BEARING ASSEMBLY           |
|             |             |             |             | 1           |             | D3137-3      | GUIDE                      |
|             |             |             |             | 1           |             | D3137-5      | WASHER                     |
|             |             |             |             | 2           |             | D3183-045    | BEARING ASSEMBLY           |
|             |             |             |             |             | 3           | D3238-1      | SHIM                       |
|             |             |             |             |             | 1           | D3238-3      | SHIM                       |
|             |             |             |             |             | 2           | D3238-5      | SHIM                       |
|             |             |             |             |             | 6           | D3238-11     | SHIM                       |
|             |             |             |             |             | 2           | D3238-13     | SHIM                       |
|             |             |             |             |             | 4           | D3238-15     | SHIM                       |
|             |             | 8           |             |             |             | AN960JD416L  | WASHER                     |
|             |             | 8           |             |             |             | MS21042L4    | NUT (OR MS21042-4)         |
|             |             | 16          |             |             |             | MS24694-S98  | SCREW                      |
|             |             |             | 1           |             |             | MS24694-S101 | SCREW                      |

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Revision: E

Date: 08.05.01